

PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Hardinge Cobra Lathe

MODEL #: LC 51

SERIAL #: C51-255

DATE RECEIVED:

P/O #:

DATE OPERATIONAL:

COMMENTS:

Fire in Grinding Bath 2012-5-24
Re Print sheet 8/26/12

MONTHLY:

- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Inspect air line filters. Replace if necessary. Record, and identify machine with the date of replacement.
- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Lubricate the tail stock quill.
- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Check hydraulic fluid levels, and top up as necessary.
- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Check the electrical cabinet filter.
- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Inspect the general condition of the machine
- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Ensure all safety devices are working, and in good condition.
- ~~J~~~~F~~~~M~~~~A~~~~M~~~~J~~~~J~~~~A~~~~S~~~~O~~~~N~~~~D~~ >Clean machine, and surrounding work area.

INTERVALS:

6 Months:

- JUNE / DEC >Change coolant. Dispose of the coolant in the appropriate container identified as " Coolant ".
- JUNE / DEC >Clean coolant tank. Refill tank. Identify the machine for the next 6 month service.

Annually:

- ☐ Clean or replace lubricator suction strainer. If replaced, record.
- ☐ Clean lubricant reservoir.
- ☐ Inspect all hydraulic hose's; LED's; and wiring. Repair or replace if necessary, and record.
- ☐ Empty, clean, and refill the hydraulic system as per the manual. Dispose of oil into the appropriate container identified as " Oil ".
- ☐ Clean and flush the coolant system.
- ☐ Dispose of the coolant in the appropriate container identified as " Coolant ".
- ☐ Inspect turret index belt, and the turret encoder belt tension.
- ☐ Inspect the spindle drive belt for wear. Inspect tension. Tighten or replace as needed. Record if replaced.
- ☐ Inspect the X and Z axis drive belt, for tension and wear. Tighten or replace as necessary. Record if replaced.
- ☐ Identify the machine for the next annual service.

Continued on back side of this page.

PERIODICAL PREVENTATIVE MAINTENANCE

BI- ANNUALLY:

- ☐ Install a fresh drive battery unit (Power case)
- ☐ Install a fresh control battery (Computer memory)
- ☐ Identify the machine for the next Bi- annual service

COMMENTS:

Change cooling fan under spindle 12/8/20 SL

Last serviced:
Date:
Initial:

Date:
Initial:

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:
12/01/24	12/02/23	12/04/19	12/04/27	12/05/17	12/06/28	12/07/26	12/8/20	30	31	29	31
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6 Month						Annual					

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Hardinge Cobra Lathe

MODEL #: LC 51

SERIAL #: C51-255

DATE RECEIVED:

P/O #:

DATE OPERATIONAL:

COMMENTS:

MONTHLY:

- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Inspect air line filters. Replace if necessary. Record, and identify machine with the date of replacement.
- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Lubricate the tail stock quill.
- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Check hydraulic fluid levels, and top up as necessary.
- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Check the electrical cabinet filter.
- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Inspect the general condition of the machine.
- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Ensure all safety devices are working, and in good condition.
- ~~FF-M-A-M-J-J-A-S-O-N-D~~ >Clean machine, and surrounding work area.

INTERVALS:

6 Months:

- JUNE / DEC >Change coolant. Dispose of the coolant in the appropriate container identified as "Coolant".
- JUNE / DEC >Clean coolant tank. Refill tank. Identify the machine for the next 6 month service.

Annually:

- ☐ Clean or replace lubricator suction strainer. If replaced, record.
- ☐ Clean lubricant reservoir.
- ☐ Inspect all hydraulic hose's, LED's, and wiring. Repair or replace if necessary, and record.
- ☐ Empty, clean, and refill the hydraulic system as per the manual. Dispose of oil into the appropriate container identified as "Oil".
- ☐ Clean and flush the coolant system.
- ☐ Dispose of the coolant in the appropriate container identified as "Coolant".
- ☐ Inspect turret index belt, and the turret encoder belt tension.
- ☐ Inspect the spindle drive belt for wear. Inspect tension. Tighten or replace as needed. Record if replaced.
- ☐ Inspect the X and Z axis drive belt, for tension and wear. Tighten or replace as necessary. Record if replaced.
- ☐ Identify the machine for the next annual service.

Continued on back side of this page.

Repair Report

ENTERED BY _____

[illegible]

PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Precimaster Turret Milling

MODEL #: Precimaster

SERIAL #: 4S 4VS 4EVS

DATE RECEIVED:

P/O #:

DATE OPERATIONAL:

COMMENTS:

WEEKLY:

> **Spindle Bearings:** Inspect oil cup level. Fill as necessary with Morlina 10 (spinle oil)

> **Knee Leadscrew:** Lubricate with #2 grease.

Jan Weeks:	Feb Weeks:	Mar Weeks:	Apr Weeks:	May Weeks:	Jun Weeks:	Jul Weeks:	Aug Weeks:	Sep Weeks:	Oct Weeks:	Nov Weeks:	Dec Weeks:
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





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12/31/07

PERIODICAL PREVENTATIVE MAINTENANCE

INTERVALS:

MONTHLY:

- J-F-M-A-M-J-J-A-S-O-N-D >Inspect the general condition of the machine. Record, and replace parts as necessary.
- J-F-M-A-M-J-J-A-S-O-N-D >Ensure all safety devices work, and inspect for damage.
- J-F-M-A-M-J-J-A-S-O-N-D >Ensure machine and surrounding work area is clean.
- J-F-M-A-M-J-J-A-S-O-N-D >Oil Pump: Check the reservoir level, and top up as necessary, by removing the upper cap, and filling with Tonna V32 or T68.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date: 12/01/27	Date: 12-2-28	Date: 12-3-28	Date: 12-4-25	Date: 12-5-28	Date: 12-6-20	Date: 12-07-26	Date: 12-08-23	Date: 12-09-26	Date: 12-10-25	Date: 12-11-28	Date: 12-12-21
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Repair Report

ENTERED BY _____

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Doosan Lathe

MODEL #: 2500LY

SERIAL #: D250LY0859

DATE RECEIVED: 2007/11/07

P/O #: 4695

DATE OPERATIONAL: 2007/11/30

COMMENTS:

WEEKLY/ MONTHLY:

J-F-M-A-M-J-J-A-S-O-N-D >Grease the chuck.

J-F-M-A-M-J-J-A-S-O-N-D >Check way oil level. Top up as necessary.

J-F-M-A-M-J-J-A-S-O-N-D >Check spindle oil. Top up as necessary.

J-F-M-A-M-J-J-A-S-O-N-D >Check hydraulic oil. Top up as necessary.

J-F-M-A-M-J-J-A-S-O-N-D >Clean the machine using a mild detergent, and clean the surrounding work area.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
By: 2 Date: 21	By: 20 Date: 20	By: 28 Date: 5/1	By: 28 Date: 28	By: 28 Date: 28	By: 28 Date: 20	By: 28 Date: 27	By: 28 Date: 20	By: 28 Date: 29	By: 28 Date: 29	By: 28 Date: 29	By: 28 Date: 04
By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2	By: 2 Date: 2
By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3	By: 3 Date: 3
By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4	By: 4 Date: 4
By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5	By: 5 Date: 5

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PERIODICAL PREVENTATIVE MAINTENANCE

INTERVALS:

6 Months:

- JUN/ DEC >Change coolant, and dispose of into the appropriate container identified as " Coolant ". Clean the tank; filters, and refill.
- JUN/ DEC >Clean strainer in way lube tank.
- JUN/ DEC >Clean strainer in hydraulic tank.
- JUN/ DEC >Visually inspect the condition of the way covers and wipers.
- JUN/ DEC >Clean the air intake fans on the electrical cabinet.
- JUN/ DEC >Clean the filters on the high pressure coolant unit.
- JUN/ DEC >Check oil level in the high pressure unit.

Annually:

- ☐ Change the filters on the high pressure coolant unit. P/N 3015-10. Record. Identify the machine for the next annual service.
- ☐ Change the spindle oil, and dispose of into the appropriate container identified as " Oil ", and identify the machine for the next annual service.
- ☐ Change the hydraulic oil, and dispose of into the appropriate container identified as " Oil ", and identify the machine for the next annual service.
- ☐ Change the high pressure unit oil, and dispose of into the appropriate container identified as " Oil ", and identify the machine for the next annual service. Refill using Mobil 1 15W-50 oil.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date: 27	Date: 30	Date: 27	Date: 28	Date: 31	Date: 20	Date: 27	Date: 20	Date: 29	Date: 29	Date: 29	Date: 04
Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ	Initial: SJ

~~need to change coolant~~
changed coolant

Repair Report

ENTERED BY _____

[illegible]

SERVICE REPORT

Lewertek Inc.

GST # 844657460

Service@Lewertek.com

www.Lewertek.com

61 Castor St.

Russell, Ontario

K4R 1E5

894-4443 / Pager & Voice Mail : 514-920-3857

Customer Name

Dant Aerospace

Address

City

Prov.

ZIP

Contact Name

Jean Luc Menard

Phone

Email

Invoice #

Date

March 8/2012

Make

Pomereoy

Model #

Decon

Serial#

P2504085

Machine Hours

Control Make & Model

Please note: Lewertek Invoices are sent electronically unless specifically requested

Additional Details:

☐ Yes ☐ No

Service Details:

Atom 2003 - No detail in books -
after power failure / phase out,

→ Found Spindle speed change contactor coil
shorted, had been previously replaced

→ Customer to source 2 new 3 Ø contactors w/
AOX. NO & AL contacts → return to install.

also del Mori Seiki CNC lathe spindle noise → seems to
be V Belts worn. - cost. to order.

Billing Details:

Date:

Labor Hours:

Travel Time:

Mileage/Notes

March 8

10:00AM - 12:30PM

2 hrs.

200 KMS.

Total Hours Worked

2.5 x \$100.00 per hour =

250.-

Overtime Hours

x \$150.00 per hour =

Total Travel Hours

2 x \$ 70.00 per hour =

140.-

Overtime Travel Hrs.

x \$100.00 per hour =

Mileage

200 x \$.44 per km =

88.-

Sub Total

478.-

IS THIS JOB COMPLETE? ☐ Yes ☒ No

Tax

HST 13% / GST 5%

62.14

Parts Ordered and Description

Parts ordered from:

Reference#

RMA #

Customer C.O.D.?

☐ Yes ☒ No

Customer P.O. #

If C.O.D., Check #

Service Technician

Customer Signature

Total Billing \$

540.14

PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Haas VF7-Series # 4

MODEL #: VF7

SERIAL #: 1089290

DATE RECEIVED: October 2011

P/O #:

DATE OPERATIONAL: 09/2011

COMMENTS:

MONTHLY:

~~JF-M-A-M-JUN-S-O-N-D~~ > Wipe down exterior of machine.

~~JF-M-A-M-JUN-S-O-N-D~~ > Check oil level in gear box.

~~JF-M-A-M-JUN-S-O-N-D~~ > Inspect way covers and lubricate with light oil.

~~JF-M-A-M-JUN-S-O-N-D~~ > Place dab of grease on the outside edge of the guide rails of the tool changer, run through all tools.

~~JF-M-A-M-JUN-S-O-N-D~~ > Check SMTC oil level in sight glass.

~~JF-M-A-M-JUN-S-O-N-D~~ > Clean/change TSC filter.

INTERVALS:

6 MONTHS:

JUN/ DEC Replace coolant.

JUN/ DEC Clean the tank.

JUN/ DEC Change air filter on electric cabinet.

See the back side of this sheet for continued instructions.

PERIODICAL PREVENTATIVE MAINTENANCE

ANNUALLY:

- ☒ Replace gear box oil.
- ☒ Clean oil filter in lube air panel.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:
Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:
	12/02/24 ork	12/04/04 B.A	12/04/08 ork	12/05/27 ork	12/06/28 ork	12/07/27 ork	12/08/25 B.A	12/09/26 ork	12/10/28 ork	12/11/29 ork	13/01/04 B.A

Repair Report

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Haas VF4-Series # 1

MODEL #: VF4

SERIAL #: 4624

DATE RECEIVED:

P/O #:

DATE OPERATIONAL: 04/1996

COMMENTS:

MONTHLY:

- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Inspect the way covers for proper operation, and lubricate as necessary, using a light oil.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Ensure to disconnect the coolant pump from the controller to power off the control before working on the coolant tank.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Clean the upper screen on the coolant tank.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Remove the middle plate on the coolant tank and remove any sediment.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Clean the inlet filter to the rotary pump.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Apply a dab of grease on the outside edge of the Geneva wheel star and guide rails on the tool changer, and run through all tools.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Apply a dab of grease on the V-flange of the tools.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Inspect and clean the air filter on the control box.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Clean the machine and surrounding work area.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Ensure all safety devices work and are in good condition.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Inspect the general condition of the machine and all lines.

INTERVALS:

6 MONTHS:

- ~~JUN/ DEC~~ Drain and replace coolant. Dispose of coolant into the appropriate container identified as " Coolant ".
- ~~JUN/ DEC~~ Clean the coolant tank, and refill.
- ~~JUN/ DEC~~ Check oil level in the gear box. Add oil until it begins to drip out of the drain tube.
- ~~JUN/ DEC~~ Inspect counterweight chains for any abnormal wear, or cracks.
- ~~JUN/ DEC~~ Lubricate the entire counterweight chains with Mobil Vactra #2.

See the back side of this sheet for continued instructions.

PERIODICAL PREVENTATIVE MAINTENANCE

ANNUALLY:

- ☐ Turn off air pressure. Disassemble and clean the small filter at the end of the lubricator (located at the left side of the head stock).
- ☐ Drain the gear box oil. Dispose of the oil in the appropriate container identified as " Oil ".
- ☐ Refill the gear box oil. Slowly fill with oil until it overflows at the bottom of the head stock.
- ☐ Check the way lube covers and oil if necessary
- ☐ Check oil filter, and clean residue at the bottom.
- ☐ Replace the air filter on the control box.

*clean + replaced
coolant
may*

Red Green Fittings
on coolant pump leaking

need new air filter
for control box

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct		
Date: 12/01/29	Date: 12/01/23	Date: 12/04/04	Date: 12/04/26	Date: 12/5-30	Date: 12/04/30	Date: 12/07/29	Date: 12/08/26	Date: 12/09/25	Date: 12/10/26	Date: 12/11/29	Date: 13/01/03
Initial: SL	Initial: SL	Initial: B	Initial: PD	Initial: R	Initial: SL	Initial: B.A	Initial: B.A	Initial: Z	Initial: PD	Initial: DA 02 89	Initial: Ote

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Repair Report

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Haas Factory Outlet

A Division of Sirco Machinery Company, Ltd.

Service Report

40 Jutland Road Toronto, Ontario M8Z 2G9

Phone: 416-255-3503

Fax: 416-255-9502

Email: service@sircomachinery.com

COMPANY Dart Aerospace

ADDRESS 1270 Aberdeen Street

CITY Hawkesbury

REGION ON

PHONE 613-632-5200

FAX 613-632-1053

CONTACT

PHONE

EXT

Date : 6/1/12

Tech : Bruno

Start : 1:30 pm

End : 5:00 pm

Hrs : 3.50

Job # 24844

Po # Paid Srv

Reg Hrs : 3.50

Ot Hrs : 0.00

Non Bill : 0.00

Trvl Time : 1.75

Distance : 0

MFG HAAS

HAAS

MODEL VF-4

SN 4624

INSTALL

7.18N

Sales # 22621

Cust # CDART00

Job Clsd : Yes

Status : Operational

Non Bill Time Expl.

SERVICE REQUESTED

Codes :

Finish spindle drive retrofit.

SERVICE PERFORMED

Found the right parameter set to use with Haas support. Fine tuned for optimal performance and asked the operator to perform a test cut. Everything is working perfectly.

Qty	Part Number	Part Description	Cust PO	Return	Core	New	Location
-----	-------------	------------------	---------	--------	------	-----	----------

Printed Name :

Signature :

Position :



Haas Factory Outlet

A Division of Sirco Machinery Company, Ltd.

Service Report

40 Jutland Road Toronto, Ontario MBZ 2G9

Phone: 416-255-3503

Fax: 416-255-9502

Email: service@sircomachinery.com

COMPANY Dart Aerospace

ADDRESS 1270 Aberdeen Street

CITY Hawkesbury

REGION ON

PHONE 613-632-5200

FAX 613-632-1053

CONTACT

PHONE

EXT

Date : 5/31/12

Tech : Bruno

Start : 2:30 pm

End : 7:15 pm

Hrs : 4.75

Job # 24844

Po # Paid Srv

Reg Hrs : 4.75

Ot Hrs : 0.00

Non Bill : 0.00

Trvl Time : 1.75

Distance : 0

MFG HAAS

HAAS

MODEL VF-4

SN 4624

INSTALL

7.18N

Sales # 22621

Cust # CDART00

Job Clsd : No

Status : Equip. Down

Non Bill Time Expl.

SERVICE REQUESTED Codes :

Alarm 149 spindle turning and 123 spindle drive fault

SERVICE PERFORMED

Magnetek spindle drive is dead. Retrofitted wiring for a Yaskawa F7 drive. Parametrized per sheet provided and tested. Wiring is operationnal as the drive goes FWD or REV as commanded but the motor barely turns wather speed command and the drive overloads after 3 seconds. Verified that speed commands are being seen by drive and that gearbox motor is not shorted. Tested with power leads disconnected and the drive operates normally. Tested all the different parameter configurations pre-loaded and the result is the same. Reconnected power leads and disconnected gearbox to test the wiring alone and it works fine but I a motor lead broke in my hands while disconnecting so it might be possible that a loose connection was causing the problem.

It is late and I don't have the proper connector with me. Will come back to complete troubleshooting.

Qty	Part Number	Part Description	Cust PO	Return	Core	New	Location
1	93-0503B	SP DRIVE KIT 5/7.5/10HP REPLAC	Paid Srv	Y			HAAS

Printed Name :

Signature :

Position :

PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Sprinkler system

COMMENTS:

WEEKLY:

Inspect and record the following " psi " readings:
Inspect the console lights, to verify they are green.

W.L - Wet line: 125psi

T.L - Town line: 120psi

D.L - Dry line: 55psi

T.S -Town supply: 110psi

Jan	Feb	Mar	Apr	May	Jun
W 1: By <u>BY</u> Date: <u>12/1/14</u>	W 1: By <u>BY</u> Date: <u>04</u>	W 1: By <u>BY</u> Date: <u>03</u>	W 1: By <u>BY</u> Date: <u>05</u>	W 1: By <u>BY</u> Date: <u>12</u>	W 1: By <u>BY</u> Date: <u>03</u>
W.L: <u>122</u> psi	W.L: <u>121</u> psi	W.L: <u>124</u> psi	W.L: <u>120</u> psi	W.L: <u>122</u> psi	W.L: <u>115</u> psi
T.L: <u>53</u> psi	T.L: <u>61</u> psi	T.L: <u>55</u> psi	T.L: <u>62</u> psi	T.L: <u>60</u> psi	T.L: <u>65</u> psi
D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>41</u> psi	D.L: <u>42</u> psi	D.L: <u>43</u> psi	D.L: <u>42</u> psi
T.S: <u>105</u> psi	T.S: <u>70</u> psi	T.S: <u>67</u> psi	T.S: <u>71</u> psi	T.S: <u>70</u> psi	T.S: <u>70</u> psi
W2: By <u>BY</u> Date: <u>12</u>	W2: By <u>BY</u> Date: <u>10</u>	W2: By <u>BY</u> Date: <u>10</u>	W2: By <u>BY</u> Date: <u>11</u>	W2: By <u>BY</u> Date: <u>17</u>	W2: By <u>BY</u> Date: <u>14</u>
W.L: <u>121</u> psi	W.L: <u>119</u> psi	W.L: <u>124</u> psi	W.L: <u>121</u> psi	W.L: <u>122</u> psi	W.L: <u>120</u> psi
T.L: <u>61</u> psi	T.L: <u>58</u> psi	T.L: <u>55</u> psi	T.L: <u>104</u> psi	T.L: <u>60</u> psi	T.L: <u>64</u> psi
D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>41</u> psi	D.L: <u>42</u> psi	D.L: <u>43</u> psi	D.L: <u>43</u> psi
T.S: <u>71</u> psi	T.S: <u>70</u> psi	T.S: <u>67</u> psi	T.S: <u>95</u> psi	T.S: <u>70</u> psi	T.S: <u>67</u> psi
W 3: By <u>BY</u> Date: <u>18</u>	W 3: By <u>BY</u> Date: <u>15</u>	W 3: By <u>BY</u> Date: <u>17</u>	W 3: By <u>BY</u> Date: <u>19</u>	W 3: By <u>BY</u> Date: <u>22</u>	W 3: By <u>BY</u> Date: <u>19</u>
W.L: <u>121</u> psi	W.L: <u>119</u> psi	W.L: <u>120</u> psi	W.L: <u>121</u> psi	W.L: <u>122</u> psi	W.L: <u>120</u> psi
T.L: <u>61</u> psi	T.L: <u>58</u> psi	T.L: <u>62</u> psi	T.L: <u>104</u> psi	T.L: <u>60</u> psi	T.L: <u>64</u> psi
D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>43</u> psi	D.L: <u>43</u> psi
T.S: <u>71</u> psi	T.S: <u>70</u> psi	T.S: <u>71</u> psi	T.S: <u>95</u> psi	T.S: <u>70</u> psi	T.S: <u>67</u> psi
W 4: By <u>BY</u> Date: <u>23</u>	W 4: By <u>BY</u> Date: <u>20</u>	W 4: By <u>BY</u> Date: <u>23</u>	W 4: By <u>BY</u> Date: <u>28</u>	W 4: By <u>BY</u> Date: <u>28</u>	W 4: By <u>BY</u> Date: <u>25</u>
W.L: <u>121</u> psi	W.L: <u>119</u> psi	W.L: <u>120</u> psi	W.L: <u>117</u> psi	W.L: <u>115</u> psi	W.L: <u>116</u> psi
T.L: <u>61</u> psi	T.L: <u>58</u> psi	T.L: <u>62</u> psi	T.L: <u>104</u> psi	T.L: <u>65</u> psi	T.L: <u>67</u> psi
D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: <u>41</u> psi	D.L: <u>42</u> psi	D.L: <u>43</u> psi
T.S: <u>71</u> psi	T.S: <u>70</u> psi	T.S: <u>71</u> psi	T.S: <u>95</u> psi	T.S: <u>70</u> psi	T.S: <u>71</u> psi
W 5: By: Date:	W 5: By <u>BY</u> Date: <u>24</u>	W 5: By <u>BY</u> Date: <u>31</u>	W 5: By: Date:	W 5: By: Date:	W 5: By: Date:
W.L: psi	W.L: <u>120</u> psi	W.L: <u>120</u> psi	W.L: psi	W.L: psi	W.L: psi
T.L: psi	T.L: <u>56</u> psi	T.L: <u>12</u> psi	T.L: psi	T.L: psi	T.L: psi
D.L: psi	D.L: <u>42</u> psi	D.L: <u>42</u> psi	D.L: psi	D.L: psi	D.L: psi
T.S: psi	T.S: <u>67</u> psi	T.S: <u>71</u> psi	T.S: psi	T.S: psi	T.S: psi

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PERIODICAL PREVENTATIVE MAINTENANCE

Jul	Aug	Sep	Oct	Nov	Dec
W 1: By: <u> </u> Date: <u>03</u>	W 1: By: <u> </u> Date: <u> </u>	W 1: By: <u> </u> Date: <u>11/14</u>	W 1: By: <u> </u> Date: <u>12/10/0</u>	W 1: By: <u> </u> Date: <u> </u>	W 1: By: <u> </u> Date: <u> </u>
W.L.: <u>115</u> psi	W.L.: <u> </u> psi	W.L.: <u>115</u> psi	W.L.: <u>120</u> psi	W.L.: <u> </u> psi	W.L.: <u> </u> psi
T.L.: <u>69</u> psi	T.L.: <u> </u> psi	T.L.: <u>80</u> psi	T.L.: <u>79</u> psi	T.L.: <u> </u> psi	T.L.: <u> </u> psi
D.L.: <u>43</u> psi	D.L.: <u> </u> psi	D.L.: <u>85</u> psi	D.L.: <u>78</u> psi	D.L.: <u> </u> psi	D.L.: <u> </u> psi
T.S.: <u>73</u> psi	T.S.: <u> </u> psi	T.S.: <u>63</u> psi	T.S.: <u>90</u> psi	T.S.: <u> </u> psi	T.S.: <u> </u> psi
W2: By: <u> </u> Date: <u>09</u>	W2: By: <u> </u> Date: <u> </u>	W2: By: <u> </u> Date: <u>12/09/0</u>	W2: By: <u> </u> Date: <u>12/10/11</u>	W2: By: <u> </u> Date: <u>12/11/12</u>	W2: By: <u> </u> Date: <u>12/12/11</u>
W.L.: <u>118</u> psi	W.L.: <u> </u> psi	W.L.: <u>116</u> psi	W.L.: <u>118</u> psi	W.L.: <u>118</u> psi	W.L.: <u>118</u> psi
T.L.: <u>68</u> psi	T.L.: <u> </u> psi	T.L.: <u>83</u> psi	T.L.: <u>71</u> psi	T.L.: <u>82</u> psi	T.L.: <u>78</u> psi
D.L.: <u>44</u> psi	D.L.: <u> </u> psi	D.L.: <u>55</u> psi	D.L.: <u>80</u> psi	D.L.: <u>80</u> psi	D.L.: <u>80</u> psi
T.S.: <u>72</u> psi	T.S.: <u> </u> psi	T.S.: <u>95</u> psi	T.S.: <u>90</u> psi	T.S.: <u>94</u> psi	T.S.: <u>88</u> psi
W 3: By: <u> </u> Date: <u>17</u>	W 3: By: <u> </u> Date: <u> </u>	W 3: By: <u> </u> Date: <u>12/09/10</u>	W 3: By: <u> </u> Date: <u> </u>	W 3: By: <u> </u> Date: <u>12/11/19</u>	W 3: By: <u> </u> Date: <u>12/12/17</u>
W.L.: <u>118</u> psi	W.L.: <u> </u> psi	W.L.: <u>114</u> psi	W.L.: <u>118</u> psi	W.L.: <u>118</u> psi	W.L.: <u>118</u> psi
T.L.: <u>68</u> psi	T.L.: <u> </u> psi	T.L.: <u>83</u> psi	T.L.: <u>81</u> psi	T.L.: <u>81</u> psi	T.L.: <u>75</u> psi
D.L.: <u>44</u> psi	D.L.: <u> </u> psi	D.L.: <u>54</u> psi	D.L.: <u>85</u> psi	D.L.: <u>80</u> psi	D.L.: <u>81</u> psi
T.S.: <u>72</u> psi	T.S.: <u> </u> psi	T.S.: <u>95</u> psi	T.S.: <u>95</u> psi	T.S.: <u>94</u> psi	T.S.: <u>91</u> psi
W 4: By: <u> </u> Date: <u>27</u>	W 4: By: <u> </u> Date: <u> </u>	W 4: By: <u> </u> Date: <u>12/09/14</u>	W 4: By: <u> </u> Date: <u>12/11/12</u>	W 4: By: <u> </u> Date: <u>12/11/20</u>	W 4: By: <u> </u> Date: <u>12/12/17</u>
W.L.: <u>120</u> psi	W.L.: <u> </u> psi	W.L.: <u>112</u> psi	W.L.: <u>119</u> psi	W.L.: <u>116</u> psi	W.L.: <u>118</u> psi
T.L.: <u>66</u> psi	T.L.: <u> </u> psi	T.L.: <u>81</u> psi	T.L.: <u>75</u> psi	T.L.: <u>83</u> psi	T.L.: <u>76</u> psi
D.L.: <u>43</u> psi	D.L.: <u> </u> psi	D.L.: <u>81</u> psi	D.L.: <u>80</u> psi	D.L.: <u>81</u> psi	D.L.: <u>81</u> psi
T.S.: <u>70</u> psi	T.S.: <u> </u> psi	T.S.: <u>91</u> psi	T.S.: <u>95</u> psi	T.S.: <u>94</u> psi	T.S.: <u>90</u> psi
W 5: By: <u> </u> Date: <u> </u>	W 5: By: <u> </u> Date: <u> </u>	W 5: By: <u> </u> Date: <u> </u>	W 5: By: <u> </u> Date: <u>12/10/17</u>	W 5: By: <u> </u> Date: <u> </u>	W 5: By: <u> </u> Date: <u>12/12/26</u>
W.L.: <u> </u> psi	W.L.: <u> </u> psi	W.L.: <u> </u> psi	W.L.: <u>116</u> psi	W.L.: <u> </u> psi	W.L.: <u>119</u> psi
T.L.: <u> </u> psi	T.L.: <u> </u> psi	T.L.: <u> </u> psi	T.L.: <u>71</u> psi	T.L.: <u> </u> psi	T.L.: <u>74</u> psi
D.L.: <u> </u> psi	D.L.: <u> </u> psi	D.L.: <u> </u> psi	D.L.: <u>80</u> psi	D.L.: <u> </u> psi	D.L.: <u>80</u> psi
T.S.: <u> </u> psi	T.S.: <u> </u> psi	T.S.: <u> </u> psi	T.S.: <u>91</u> psi	T.S.: <u> </u> psi	T.S.: <u>91</u> psi

INTERVAL:

Annually

Have sprinkler system inspected by General Fire Protection Co:

COMMENTS:

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12/10/10

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12/10/10

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Repair Report

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Haas VF4-Series # 2

MODEL #: VF4

SERIAL #: 11067

DATE RECEIVED:

P/O #:

DATE OPERATIONAL: 07/1997

COMMENTS:

MONTHLY:

- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Inspect the way covers for proper operation, and lubricate as necessary, using a light oil.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Ensure to disconnect the coolant pump from the controller to power off the control before working on the coolant tank.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Clean the upper screen on the coolant tank.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Remove the middle plate on the coolant tank and remove any sediment.
- ~~NA J-F-M-A-M-J-J-A-S-O-N-D~~ >Clean the inlet filter to the rotary pump.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Apply a dab of grease on the outside edge of the Geneva wheel star and guide rails on the tool changer, and run through all tools.
- ~~NA J-F-M-A-M-J-J-A-S-O-N-D~~ >Apply a dab of grease on the V-flange of the tools.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Inspect and clean the air filter on the control box.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Clean the machine and surrounding work area.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Ensure all safety devices work and are in good condition.
- ~~J-F-M-A-M-J-J-A-S-O-N-D~~ >Inspect the general condition of the machine and all lines.

INTERVALS:

6 MONTHS:

- ~~JUN/DEC~~ >Drain and replace coolant. Dispose of coolant into the appropriate container identified as "Coolant".
- ~~JUN/DEC~~ >Clean the coolant tank, and refill.
- ~~JUN/DEC~~ >Check oil level in the gear box. Add oil until it begins to drip out of the drain tube.
- ~~JUN/DEC~~ >Inspect counterweight chains for any abnormal wear, or cracks.
- ~~JUN/DEC~~ >Lubricate the entire counterweight chains with Mobil Vactra #2. **> N/A**

See the back side of this sheet for continued instructions.

PERIODICAL PREVENTATIVE MAINTENANCE

ANNUALLY:

- ☒ Turn off air pressure. Disassemble and clean the small filter at the end of the lubricator (located at the left side of the machine).
- ☐ Drain the gear box oil. Dispose of the oil in the appropriate container identified as " Oil ".
- ☒ Refill the gear box oil. Slowly fill with oil until it overflows at the bottom of the head stock.
- ☒ Check the way lube covers and oil if necessary
- ☒ Check oil filter, and clean residue at the bottom.
- ☒ Replace the air filter on the control box.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date: 12/01/29	Date: 10-02-24	Date: 12/04/04	Date: 12/04/27	Date: 12/05/25	Date: 12/06/28	Date: 12/07/27	Date: 12/08/22	Date: 12-9-26	Date: 12/10/26	Date: 12/11/29	Date: 13/01/03
Initial: KT	Initial: JE	Initial: SJ	Initial: SJ	Initial: SJ	Initial: FK	Initial: FK	Initial: P	Initial: AS 25	Initial: AS 08	Initial: FK	Initial: PD

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SJ

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FK

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FK

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P

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AS
25

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12/10/26
AS
08

ENTERED
12/11/29
FK

ENTERED
13/01/03
PD

Repair Report

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Charles Lathe

MODEL #: CH430X1000/02165

SERIAL #: 2165

DATE RECEIVED:

P/O #:

DATE OPERATIONAL:

COMMENTS:

MONTHLY:

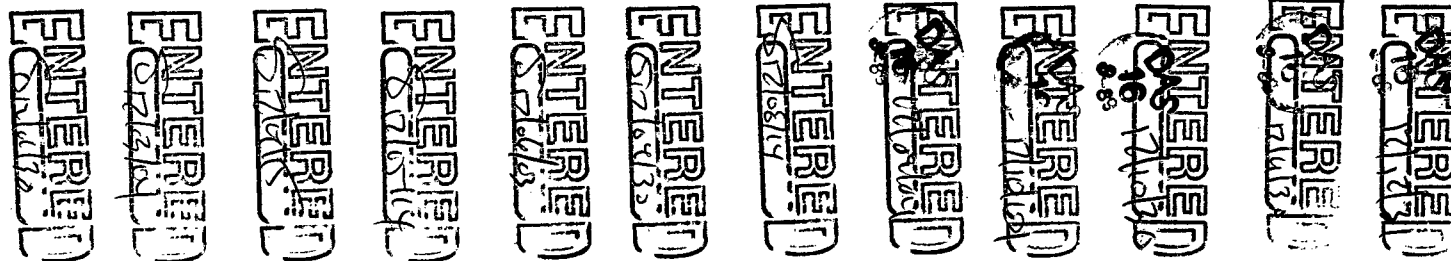
- ~~31~~ M-A-M-J-A-S-O-N-D >Check oil and coolant levels. Top up as necessary.
- ~~1~~ F-M-A-M-J-A-S-O-N-D >Clean machine, and surrounding work area.
- ~~1~~ F-M-A-M-J-A-S-O-N-D >Disassemble 3 jaw chuck, and clean.
- ~~1~~ F-M-A-M-J-A-S-O-N-D >Inspect the general condition of the machine.
- ~~1~~ F-M-A-M-J-A-S-O-N-D >Ensure all safety devices work, and are in good condition.

INTERVALS:

Annually:

- ☐ Change coolant and dispose of in the appropriate container identified as " Coolant ".
- ☐ Identify the machine for the next annual service.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date: 12-1-27	Date: 12-2-28	Date: 12-3-28	Date: 12-4-26	Date: 31	Date: 12-6-21	Date: 27	Date: 29	Date: 30	Date: 25	Date: 28	Date: 12-22-1
Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial: 	Initial:



Repair Report

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Jaespa Bandsaw

MODEL #: W 320 AZ

SERIAL #: 20475 00

DATE RECEIVED:

P/O #:

DATE OPERATIONAL:

COMMENTS:

MONTHLY:

- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Clean all draining surfaces, using the rinse hose.
- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Draw off the chip box at the front side.
- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Remove the chips, and dispose of into the metal recycling container.
- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Check the coolant-water-emulsion. Mixture should amount to 5% - 10%. Use Refractometer, and adjust mixture accordingly.
- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Inspect the general condition of the machine and grease.
- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Clean machine and surrounding work area.
- ~~JF-M-A-M-J-J-A-S-O-N-D~~ Ensure all safety devices are working, and are in good condition.

INTERVALS:

Annually:

- ☐ Pull out coolant tank as far as possible.
- ☐ Remove fixing screws from the cooling pump.
- ☐ Take off coolant pump and hose connections from the coolant tank and clean the strainer.
- ☐ Drain coolant and dispose into the appropriate waste container identified as "Coolant".
- ☐ Clean coolant tank and all components.
- ☐ Re-assemble and insert the coolant tank back into position.
- ☐ Refill coolant tank. Refer to page 29 of manual for information.
- ☐ Identify the machine for the next annual maintenance.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date: 26	Date: 23	Date: 12/04/04	Date: 12/04/08	Date: 31	Date: 21	Date: 26	Date: 29	Date: 30	Date: 25	Date: 28	Date: 21
Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>B.A</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>	Initial: <i>Lo</i>

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Repair Report

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PERIODICAL PREVENTATIVE MAINTENANCE

MACHINE: Haas VF4-Series # 3

MODEL #: VF4

SERIAL #: 34162

DATE RECEIVED:

P/O #:

DATE OPERATIONAL: 02/2004

COMMENTS:

MONTHLY:

- ~~VFMA-JJ-SON-D~~ >Inspect the way covers for proper operation. Lubricate with a light oil if necessary.
- ~~VFMA-M-JJ-SON-D~~ >Apply a dab of grease on the tool changer arm.
- ~~VFMA-M-JJ-SON-D~~ >Remove and clean the screen on the coolant tank.
- ~~VFMA-M-JJ-SON-D~~ >Inspect all hoses and lubrication lines for cracks. Replace if necessary, and record.
- ~~VFMA-M-JJ-SON-D~~ >Inspect the general condition of the machine.
- ~~VFMA-M-JJ-SON-D~~ >Inspect and clean the air filter on the controll box.
- ~~VFMA-M-JJ-SON-D~~ >Clean machine and surrounding work area
- ~~VFMA-M-JJ-SON-D~~ >Ensure all safety devices are working, and are in good condition.

INTERVAL:

Annually:

- ☒ Check oil filter, and clean residue at the bottom.
- ☒ Replace the air filter on the control box
- ☒ Check S.M.T.C oil in the sight glass. Top as necessary.
- ☒ Drain and change the coolant, and clean the tank. Dispose of coolant in the appropriate container identified as " Coolant ".
- ☒ Identify the machine for the next annual service.

Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:	Date:
12/01/27	12/02/23	12/04/04	12/04/27	12/06/03	12-06-28	12/07/25	12/08/16	12/10/01	12/10/26	12-11-29	12/12/18
Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:	Initial:
F.K.	F.K.	F.K.	F.K.	P.O.	J.L.	A.L.	P.P.	F.K.	[Signature]	[Signature]	F.K.

Repair Report

ENTERED BY _____

[illegible]